

OK 53.00



OK 53.00 is a basic electrode with especially good mechanical properties and therefore often used when the requirements are extra tough. The electrode is tolerant to wide variations in the analyses of the base metal. Very stable for root runs.

Classifications	SFA/AWS A5.1 : E7016 EN ISO 2560-A : E 42 4 B 12 H10
Approvals	ABS 3H10 3Y BV 3 3YH10 CE EN 13479 DB 10.039.09 DNV 3 YH15 GL 3YH10 LR 3Y H15 VdTUV 00630

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Diffusible Hydrogen	<10.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Lime Basic

Typical Tensile Properties

Condition

ISO

AWS

Typical Charpy V-Notch Properties

Condition	Testing Temperature
AWS	
As Welded	-30 °C
ISO	
As Welded	-40 °C

Deposition Data

Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	80-110 A	26 V	0.63	83	53 sec	0.82 kg/h
3.2 x 350 mm	80-150 A	26 V	0.68	48	59 sec	1.28 kg/h
3.2 x 450 mm	80-150 A	26 V	0.65	38	67 sec	1.41 kg/h
4.0 x 450 mm	100-220 A	25 V	0.64	25	70 sec	2.05 kg/h
5.0 x 450 mm	180-320 A	30 V	0.67	16	88 sec	2.62 kg/h